

Work Order ID 61144

Tuesday, August 10, 2010 8:33:50 AM



Page 1

Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step LH

Stop



Start Date: 8/11/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-8-10 Tooling: _____ Date: _____

Run Start



QC:

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

0.00

0.00

110



Pick Kit

*HJ for BG 10-8-25
603 CcW 1118*
HJ for BG 10-8-25
*See
P10
in pick
list →*
P10/8/20 (4)

Packaging

Packaging

120



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

0.00

*4
100512
- Step I: Packed in boxes w/ paper wrap
- Kits separated in boxes re
packing.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

0.00

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-023
Location: 71 PPP Rev: 6

140



QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 61144



Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			120	Each	1,889.000	3	12			

BOLT

Location	Loc Qty	Loc Code
ST350	1889	
114108	14	
114416	12	
114523	2	
114941	861	M114523
115300	1000	

AN4C14A



Bolt

Purchased No

120 Each 89.0000

4

16

PTO
→

Location	Loc Qty	Loc Code
ST358	89	
111902	89	

AN4C15A



Bolt

Purchased No

120 Each 124.0000

8

32

Location	Loc Qty	Loc Code
ST358	124	
111819	1	
113595	11	
113603	10	
114330	2	
114442	50	
114523	50	M114523

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

AN960C10

NAS1149C0363

Purchased

No

120

Each

0.0000

3

12



m/13824

Lc

WASHER

AN960C416L

Purchased

No

120

Each

820.0000

24

96



Lc

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	44	
104925	44	
ST346	776	
106785	38	
107008	10	
112794	287	
112828	400	112828
69220	41	

D2731-7

Manufactured

No

120

Each

83.0000

4

16

Lc/

P70
→

Mounting Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST470	83	
52330	35	
55773	8	
59202	40	

D2732

Manufactured

No

120

f

324.9310

2

8 ✓

59202

8 ✓

Lc 10/12/04 (4)

Rubber Extrusion

XOL1616
@ 3.0" long
6/10/10/15

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST412	324.931	
56516	324.931	

156516

W/O: 61144	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-09-02	120	D2732 cushion qty is 8 not 2, please correct qty to 8 on both - Q23 & -024 BOM's. <i>perm change</i>	/A	10.09.02		/1005.02	/1005.02

Part No: D206-628-023 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Heli-Access-Step LH

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

D2842-041



Step Assembly, 206 Float

Manufactured

No

120

Each

0.0000

1

4



6/153

L

D2844-1



Arm

Manufactured

No

120

Each

16.0000

2

8



8

B61155 10/9/11 sl

D2844-3



Arm

Manufactured

No

120

Each

10.0000

1

4



1 B61156 10/9/11 sl

1 B50825 1x

D3394-043



Lug Assembly

Manufactured

No

120

Each

65.0000

4

16



16

L10/9/11 (4)

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step LH

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 4.00

Required Qty: 4.00

J MS21043-4



Nut

Purchased

No

120

Each

1,211.000

12

48



Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1171	
112492	25	
113069	8	
114348	338	
114523	500	
114784	300	

J NAS1515H3



Washer

Purchased

No

120

Each

134.0000

3

12



Location	Loc Qty	Loc Code
ST277	134	
111268	134	

J NAS1515H4L



WASHER

Purchased

No

120

Each

888.0000

24

96



111268

111268 (4)

Location	Loc Qty	Loc Code
FG	40	
103691	40	
ST277	848	
112492	223	
114236	268	
114265	357	

1114236

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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**5.2 D206-628-013/-014/-023/-024/-033/-033 FLOAT COMPATIBLE DART HELI-
ACCESS-STEPS™ PARTS LIST**

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
			1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE